

OPERATING INSTRUCTIONS: VULCATHENE FUSION WELDER

MAKING THE ENFUSION JOINT

Before making the enfusion joint, it is important to check that the power source is present. With 11amp capacity. The enfusion controller provides for reasonable and normal power. Should be checked to assure that rated output is being provided.

PREPARATION

- Cut the pipe square and remove all burrs and loose material.
- Using a pipe scraper, scrape the end of the pipe equivalent to the depth of the socket.
- Insert the pipe all the way to the stop at the bottom of the socket.
- Decide whether the joint will be welded singly or in series.
- Loosely fit the appropriate sized clamps (s) over the hub (s) of the socket(s).
- Tighten the clamp(s) round the hub(s) of the sockets.

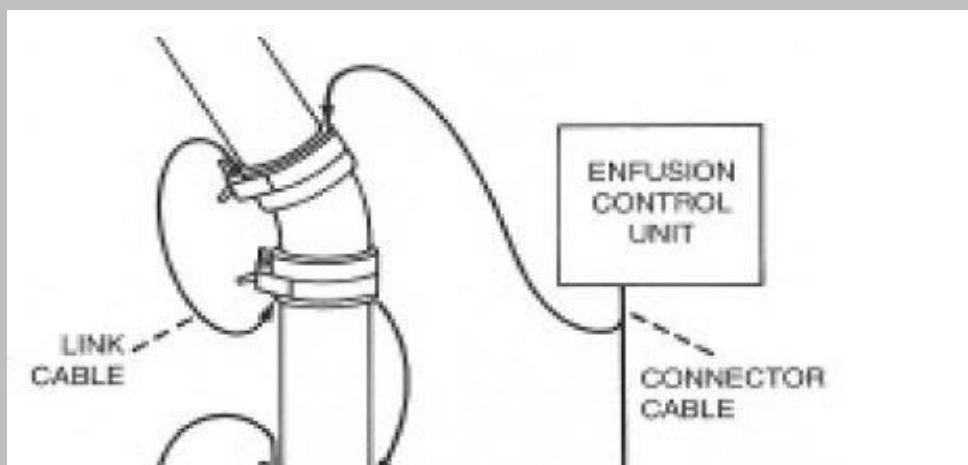
It is important that the clamp(s) is/are tightened sufficiently to stop the pipe from moving.

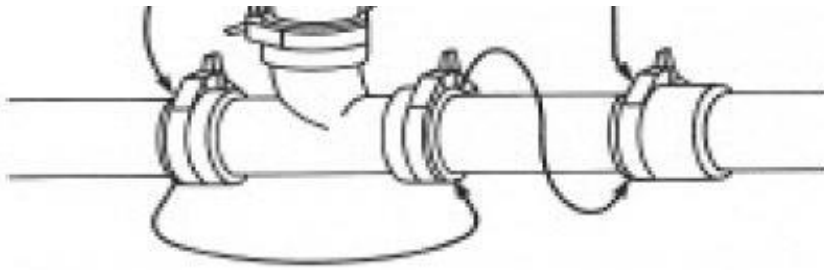
WELDING

- Turn the Enfusion unit on and it will self test.
- Follow the instructions on the hand held display to "Connect lead and fitting".
- Press the START button to begin welding.
- The Enfusion unit will count down the time while monitoring the welding process.
- When complete, the display will show "Remove leads from fitting(s)". Wait for the unit to cool.
- The Enfusion unit will now reset, ready for the next operation.
- Leave the joint(s) undisturbed for at least 5 minutes before removing the clamps.

Making multiple Enfusion joints

The chart indicates the number of joints which can be fused at any one time utilising the unit. A number of fittings or combination of sizes is possible; please refer to the installation manual for details.





Typical Multiple Jointing Configuration



providing 88 to 149 volts at 40 to 70 cycles
power variation, but generators in particular

the socket plus 50%.

) to be joined and push flush with the socket opening.

rotating in the socket. Do not over-tighten the clamp(s).

ing(s)". If using a single joint, connect the output leads to one joint. If multiple joi

parameters for faults.

t 30 seconds to allow the joint to cool, before carefully disconnecting the leads f

clamp(s).

additional link cables in series.

n portion of the Vulcathene Technical Brochure.

SIZE	JOINTS
38mm	8
51mm	6
76mm	4
102mm	3
152mm	2

ess Specialists

nts, use the link leads as required.

rom the fittings.

